

**Work Order ID 93196**

November-15-12 9:20:25 AM

**\*93196\***

Page 1

Item ID: D3272-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step

Start Date: 11/15/12 Start Qty: 10.00 **\*10\***

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 10.00 **\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-11-16

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

Large Fab

\*\*\*SQUARE ONE END BEFORE CUTTING OTHER END\*\*\*

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

10 0 Ac 12/11/22

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

QC

Memo

0.00

Quality Control

10 1 JS 12-11-22

# Work Order ID 93196

November-15-12 9:20:25 AM

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Page 2

Item ID: D3272-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step  
 Start Date: 11/15/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 11/30/12 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> <u>Step</u> <u>Cell</u> Memo	0.00 0.00				(10)	0		Ac 12/11/22
130 <b>*130*</b> QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/11/23 MF 12-11-22

# Picklist Print

November-15-12 9:20:25 AM

Page 1

Work Order ID: 93196

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 11/15/12

Required Date: 11/30/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	160.1300	1	10		12/11/22	

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	134.4	
81507	1.88	
83894	12.38	
88513	7.14	
<u>89750</u>	113	
WA013	9.36	
75781	2	
77612	7.36	

10





DESIGN <b>9P</b>	DRAWN BY <b>JB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>JB</b>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04 **JB**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

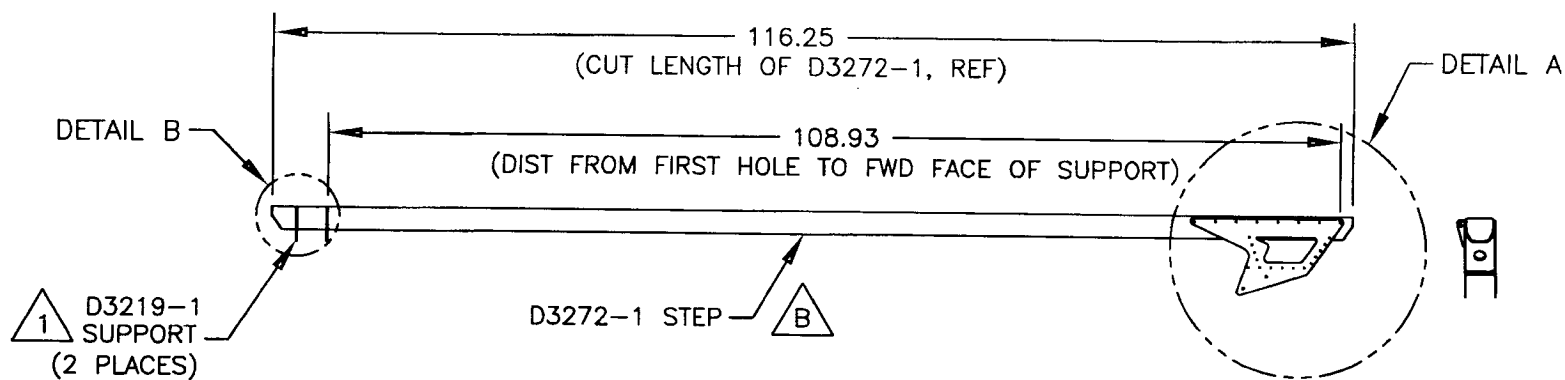
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

93196 MLS  
12-11-10  
UNCONTROLLED  
SUBJECT  
12-11-10

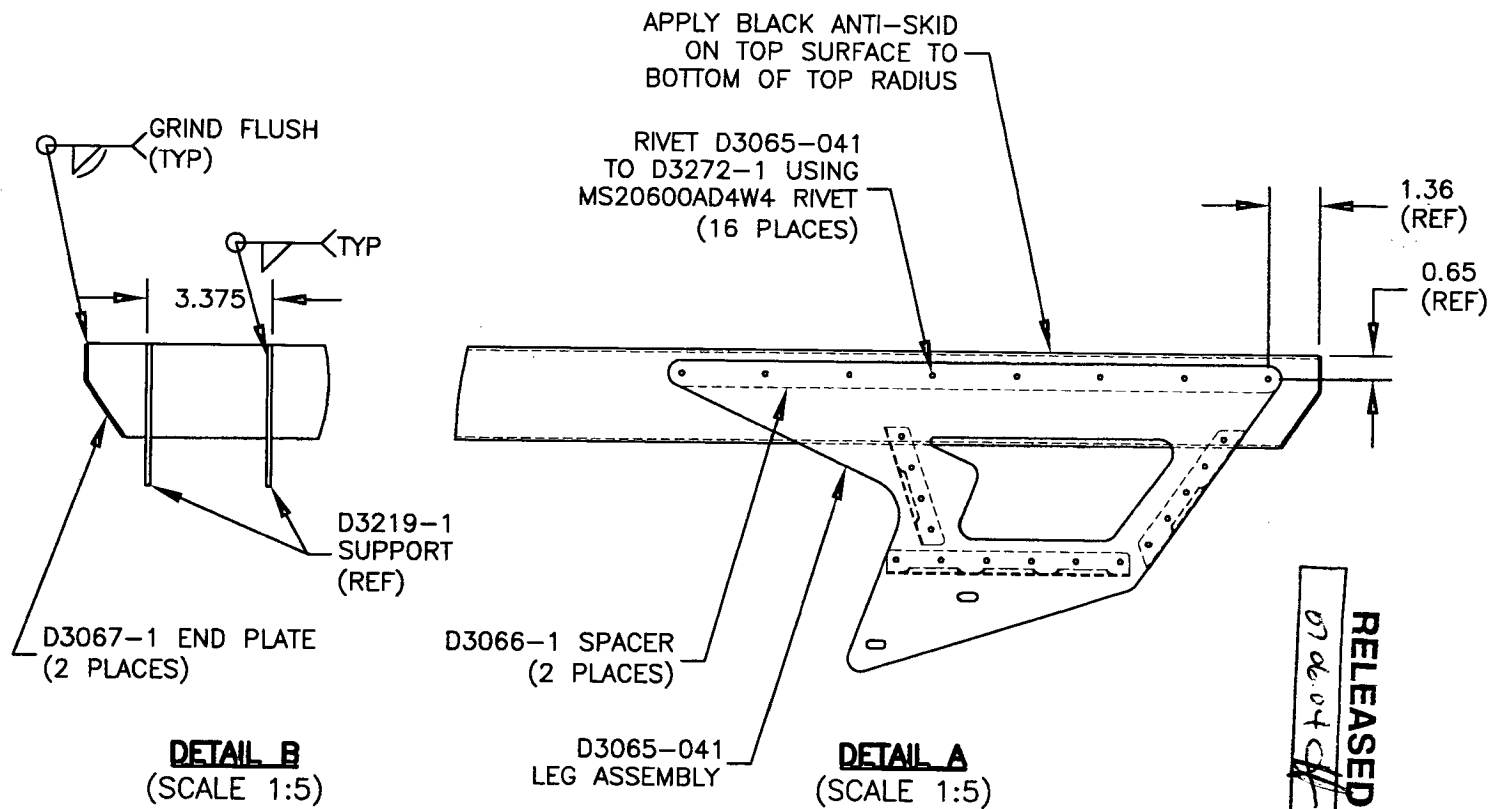
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93194



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



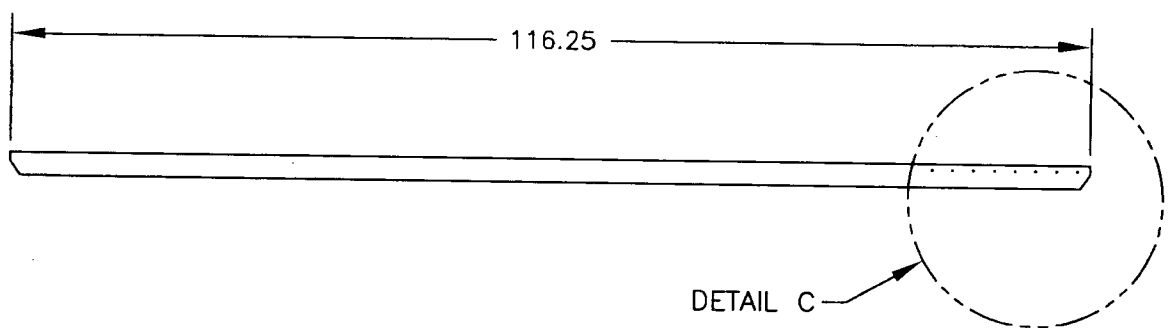
RELEASED

DESIGN	90	DRAWN BY	JR	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	JE	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B SHEET 2 OF 3
		SCALE	1:20	

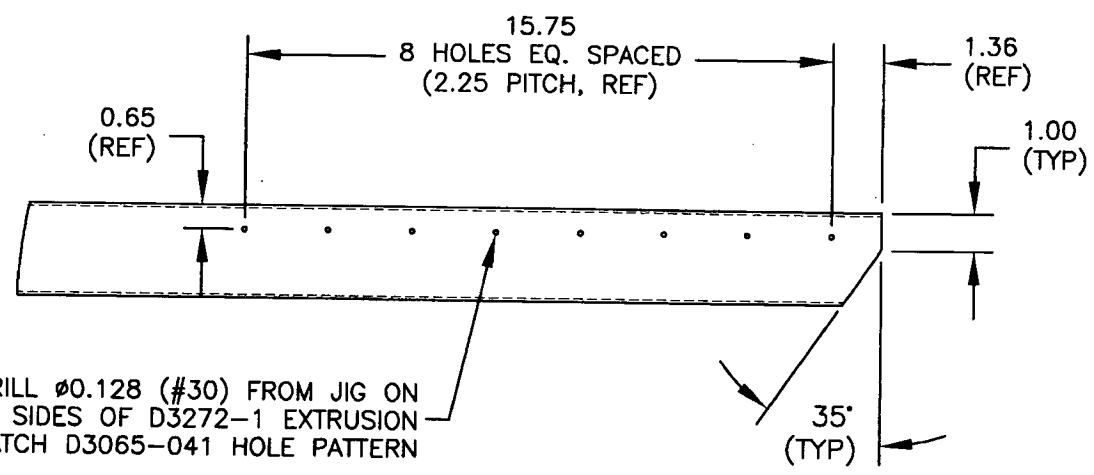
93196



DESIGN	90	DRAWN BY	J.B.	DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



**△ B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\varnothing 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED  
07.06.04

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